

Date: Tuesday, 9/4/2007 11:30:21 AM  
 User: Kim Johnston

## Process Sheet

split  
 SB 07/10/10

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUCT  
 Job Number : 34418  
 Estimate Number : 12315  
 P.O. Number : N/A  
 This Issue : 9/4/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : SMALL /MED FAB  
 Previous Run : 32049  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 06-03-02 JLM  
 Est Rev:B As per Rev B 06-05-24 JLM

Part Number : D34731  
 Drawing Number : D3473 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : N/A  
 Due Date : 10/4/2007 Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.6305 sf(s)/Unit Total: 3.7832 sf(s)  
 304/316 0.018 SHEET  
 Batch: M105 490

SAD 07/09/05

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 Cut as per Dwg D3473  
 Dwg Rev: B  
 Prog Rev: B

SAD 07/09/05

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/05

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

counted  
 15  
 En 07/09/05

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3473

3-Form Small Flange as per Dwg D3473 using DT8861 Base & Dt8847B Male Die

mf 07-10-24 (9)



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/10	5	<del>Split</del> Split u/o Split on the first u/o who we swap all piece see NCR all piece were swap	SB	07/10/10	5	07-10-25	07-10-25	
07/10/10	5	Split u/o -1 was split balance 9	SB	07/10/10	9	07-10-25	07-10-25	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/09  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/10	5	6 piece were swap piece were to short under review		Swap destroy replaced on splits.	SB 07/10/10	07-10-25	07-10-25	07-10-25

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 34418

Part Number: D34731

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Form Large Flange as per Dwg D3473 Using DT8862

5-Spot Weld as per Dwg 3473

MF 07-10-25. (9)

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/26 (9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/26 (9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 612

MF 07-10-26 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

28/10/27 (9)

Job Completion



u 07.10.26



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

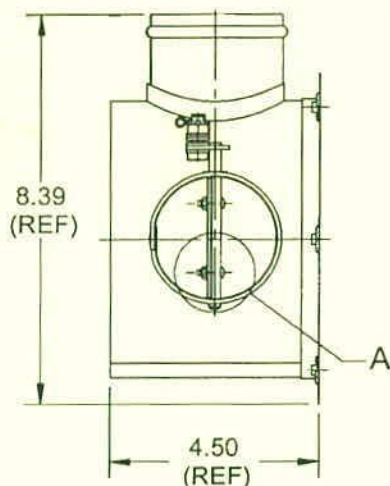
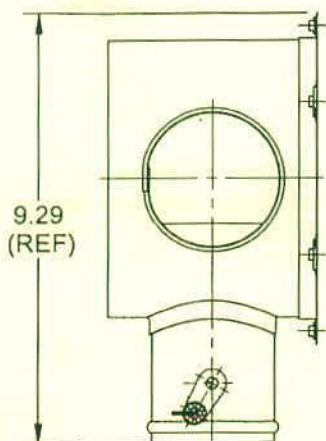




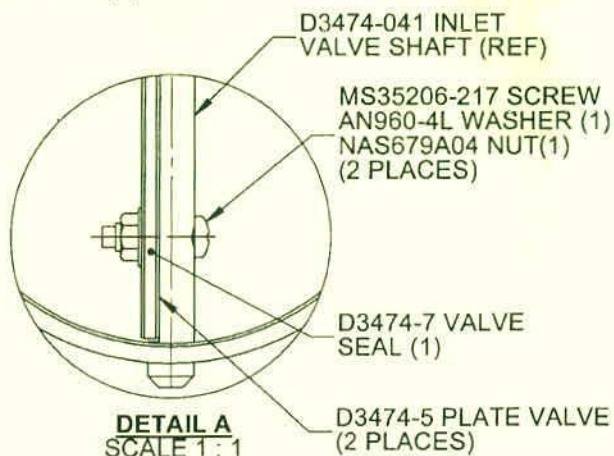
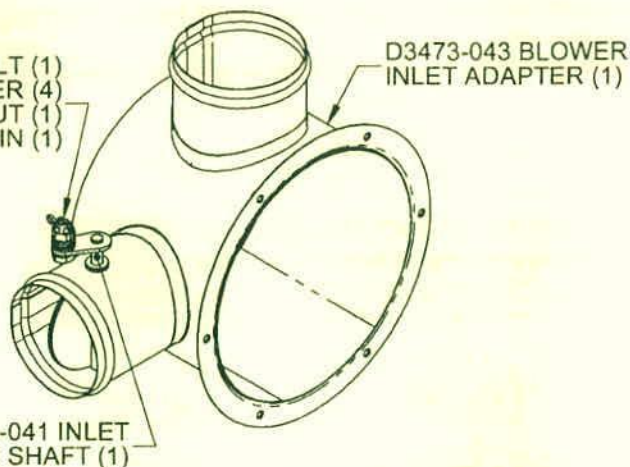


**DART****RELEASED**  
06-05-16

DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3473</b>	REV. B SHEET 1 OF 7
DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	



D3470-9 BOLT (1)  
AN960-416 WASHER (4)  
AN310-4 NUT (1)  
MS24665-153 COTTER PIN (1)



### **D3473-041 BLOWER INLET ADAPTER**

#### **NOTES:**

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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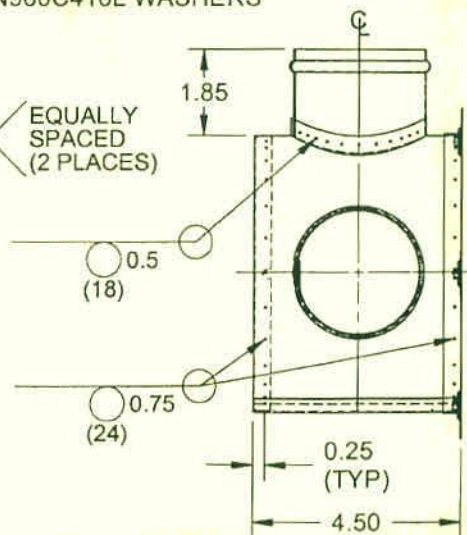
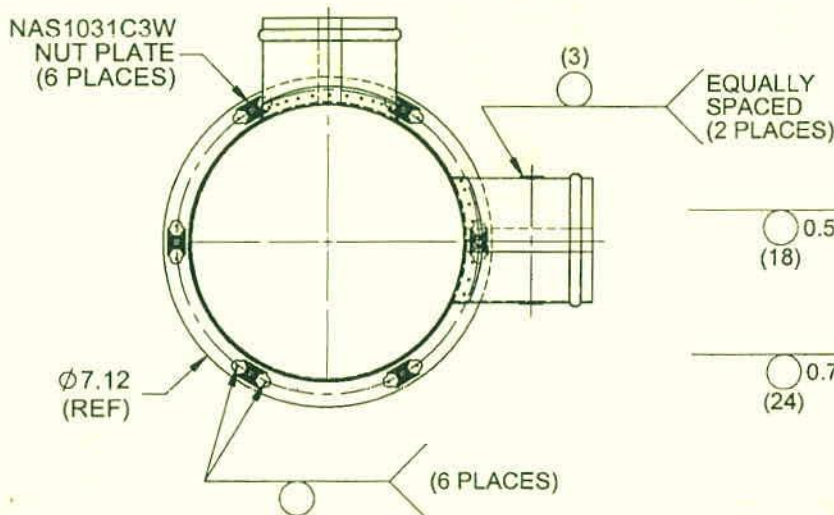
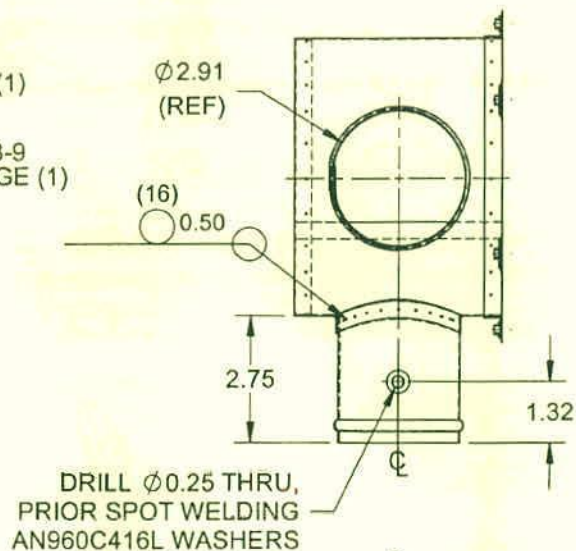
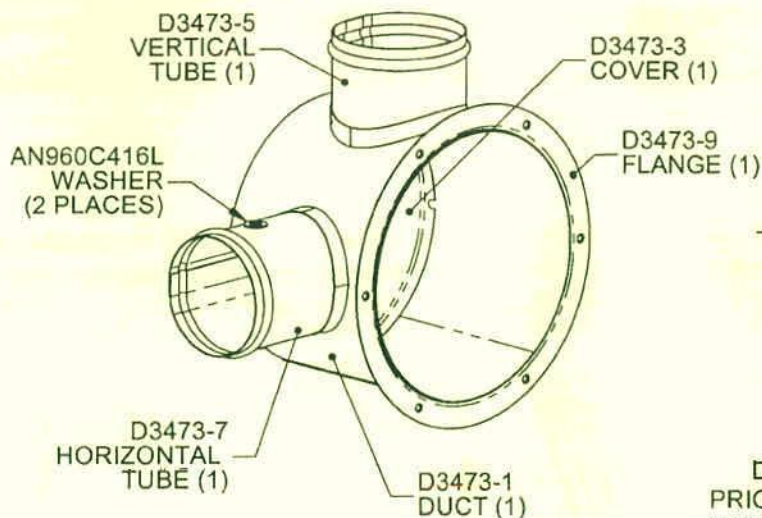
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CHECKED H	APPROVED H	DRAWING NO. <b>D3473</b>	REV. B SHEET 2 OF 7
DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b> SCALE 1:4	

RELEASED  
06-05-16



### D3473-043 BLOWER INLET WELDMENT

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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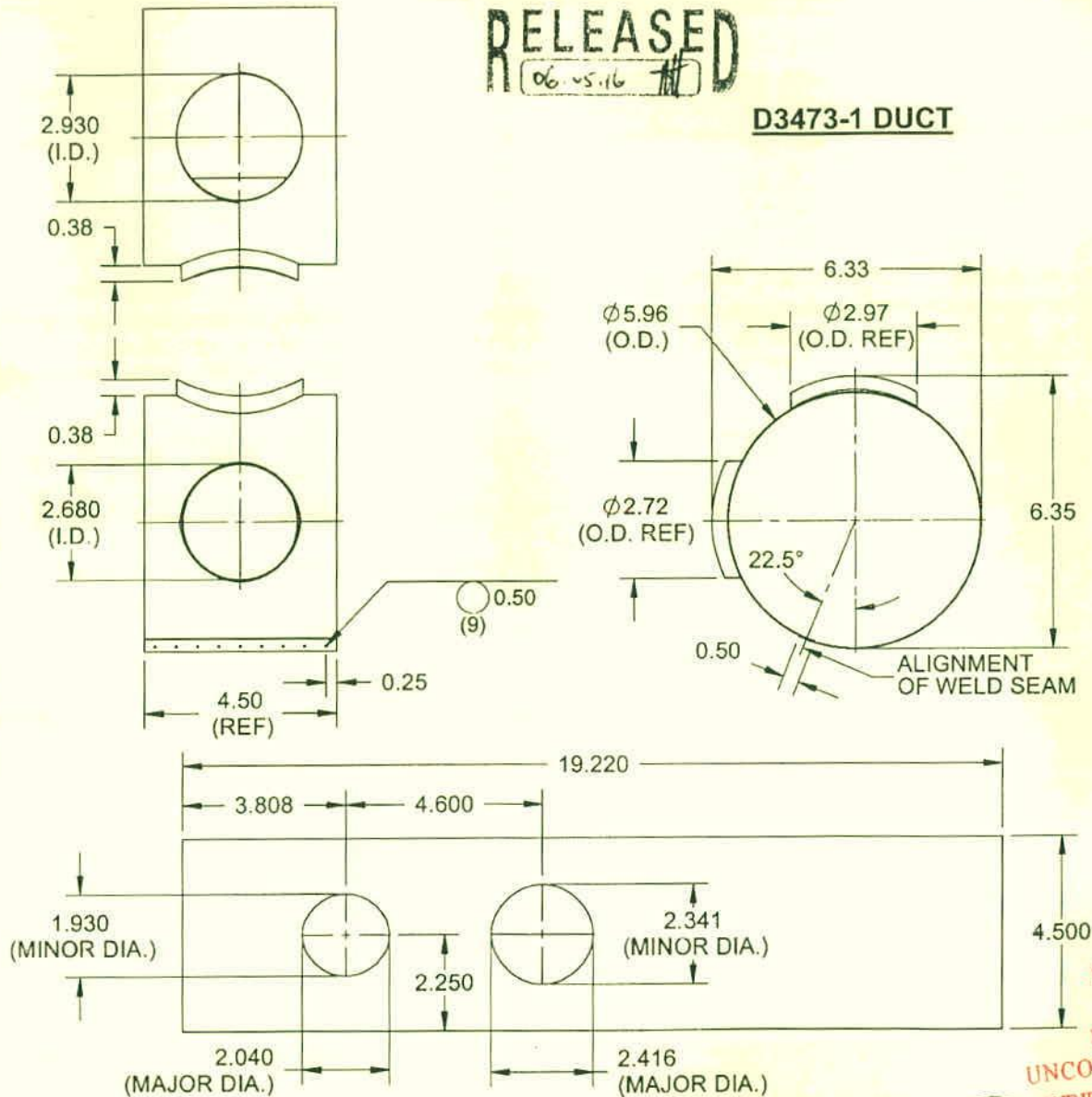
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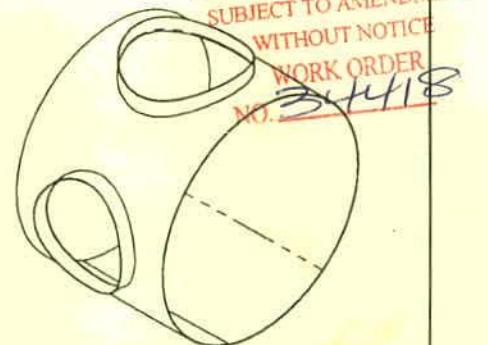


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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

**RELEASED**  
*06-05-16***D3473-1 DUCT****D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



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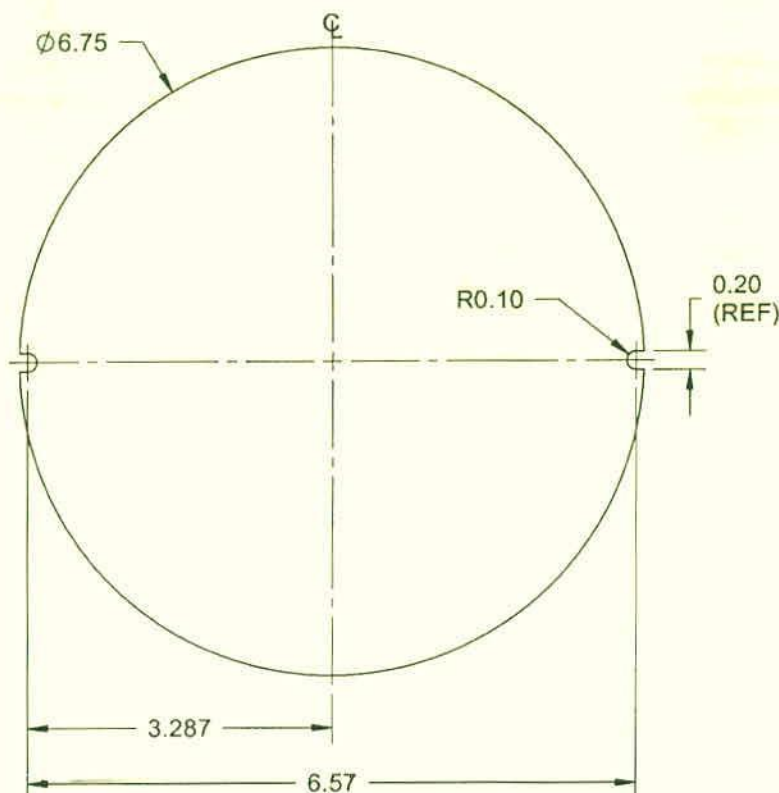




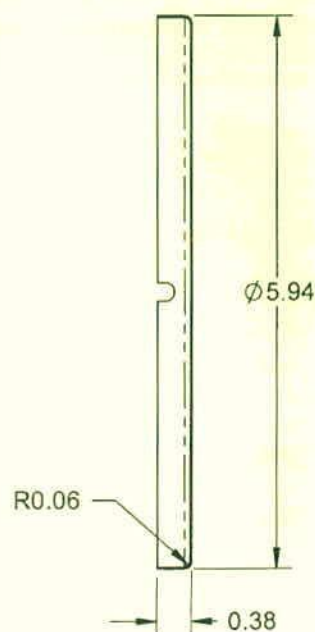


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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

RELEASED  
*[Stamp]*



**D3473-3F COVER FLAT PATTERN**



**D3473-3 COVER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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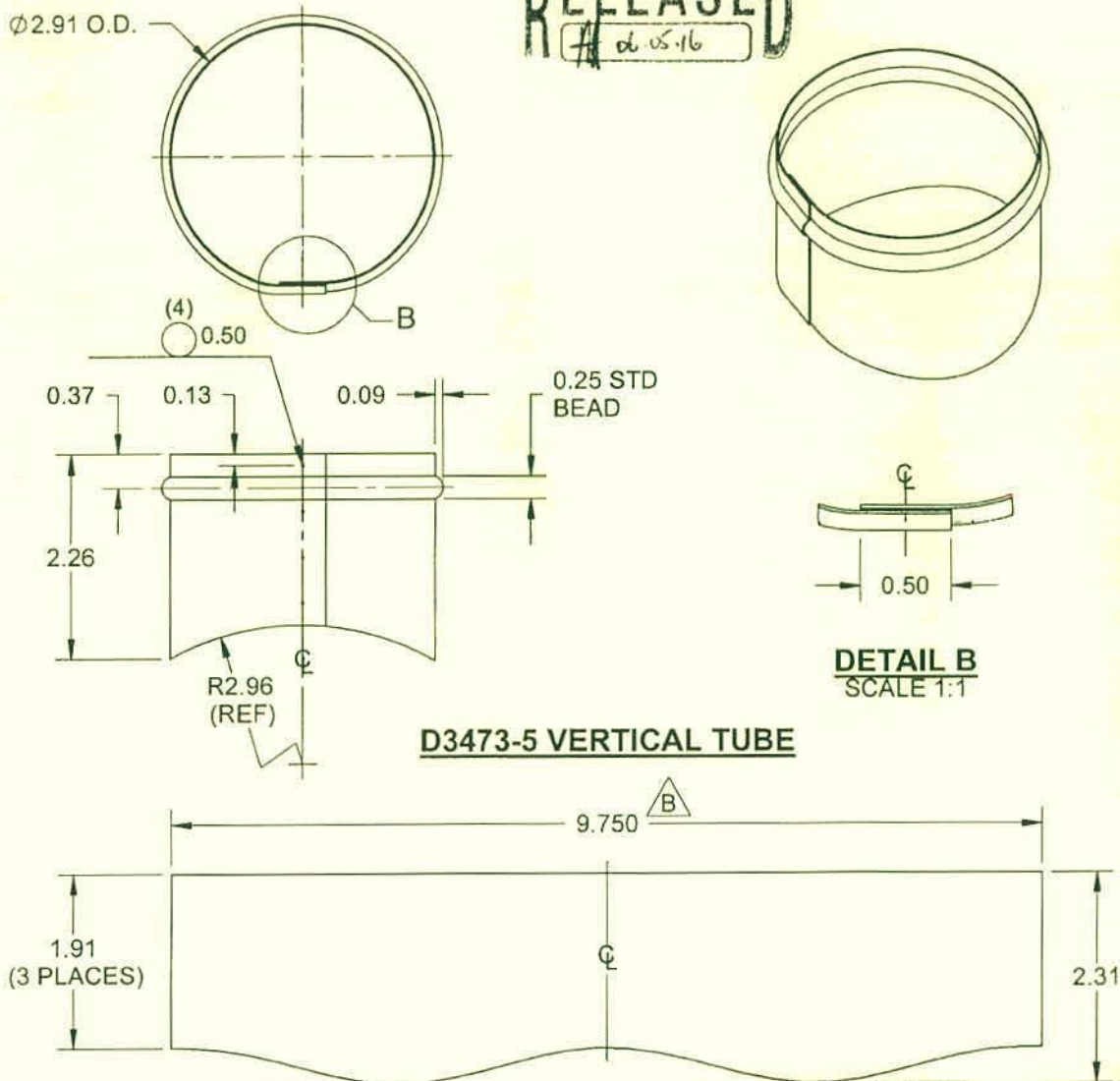
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

**RELEASED**  
*# d. 05.16***D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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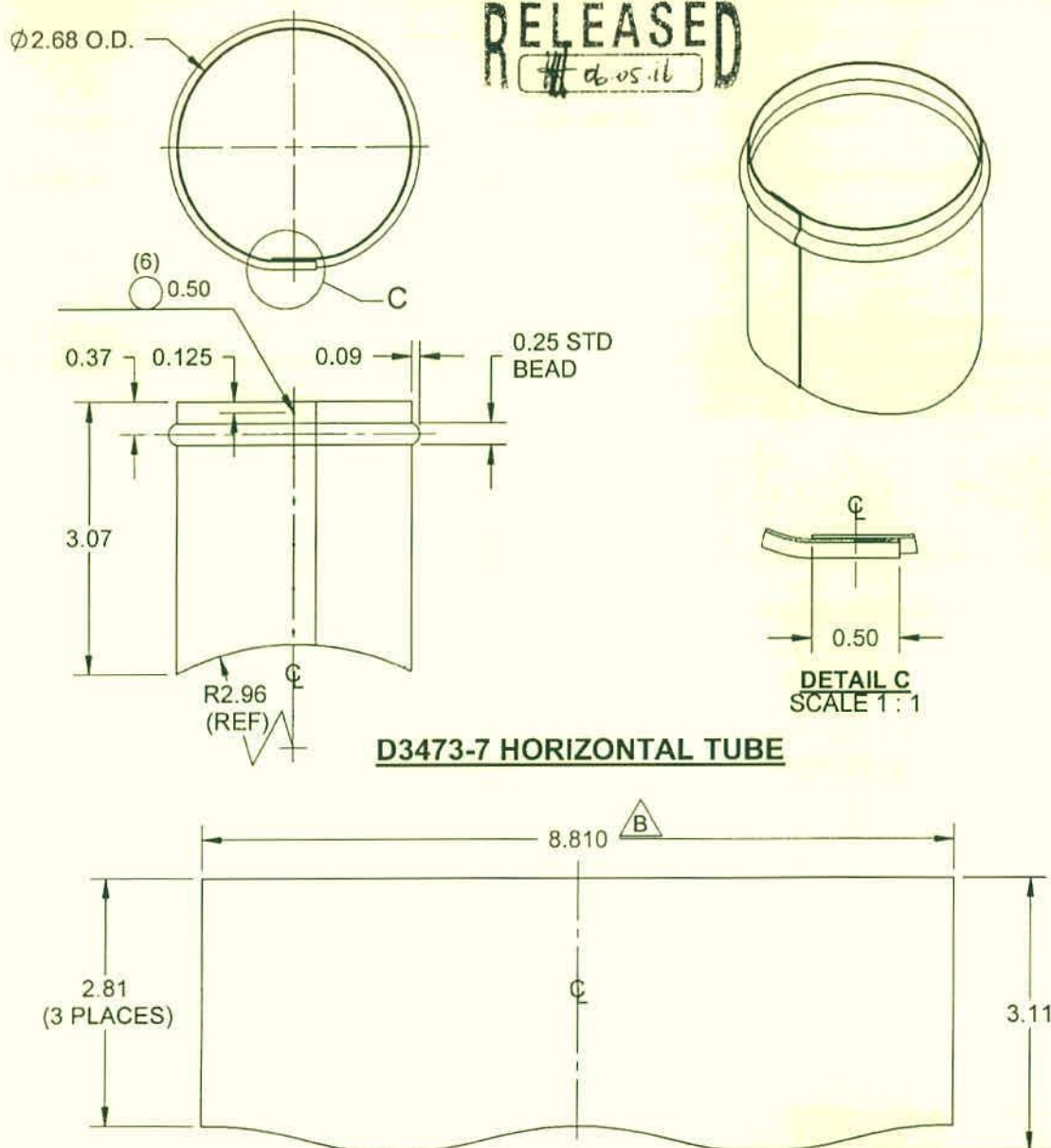
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	
		SCALE 1:2	



### D3473-7F HORIZONTAL TUBE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

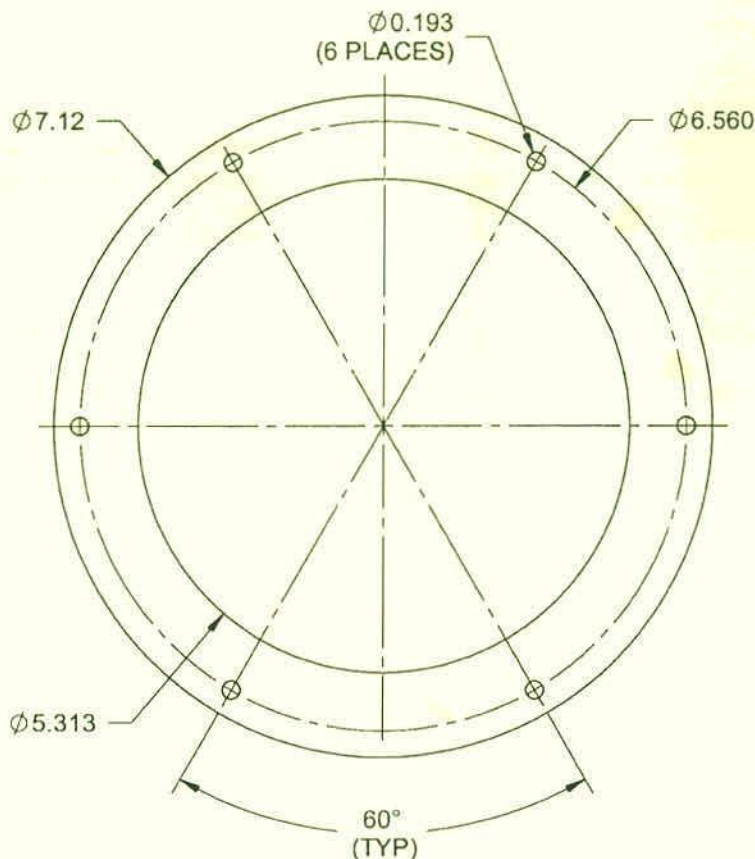
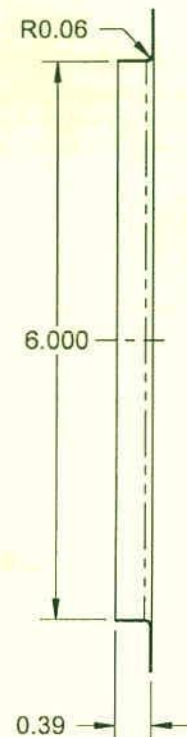
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

**RELEASED**  
*[Stamp]***D3473-9F FLANGE FLAT PATTERN****D3473-9 FLANGE  
BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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## FIRST ARTICLE INSPECTION CHECKLIST

X

## First Article

## Prototype

[illegible]

Measured by:	LB	Audited by:	LS	Prototype Approval:	
Date:	07-10-15	Date:	07/10/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 32

EMPLOYEE: Melanie Fautour

PART NUMBER: D 3473-1

JOB NUMBER: B 34418

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 1018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ / ]	[ ]
PENETRATION:	[ / ]	[ ]
PULL STRENGTH:	[ / ]	[ ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/00/24

QUALIFIER: SB



